

Date: Thursday, 9/14/2006 7:29:40 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : TUBE
<b>Job Number</b> : 28567	
<b>Estimate Number</b> : 12243	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D34773
<b>This Issue</b> : 9/14/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3477 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 26598	<b>Material</b> : N/A
<b>Written By</b> : <u>                    </u>	<b>Due Date</b> : 10/6/2006
<b>Checked &amp; Approved By</b> : <u>                    </u>	<b>Qty:</b> 8 <b>Um:</b> Each
<b>Comment</b> : Est Rev:A New Issue 06-02-07 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S26GA	304/316 0.018 SHEET
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**Comment:** Qty.: 0.1985 sf(s)/Unit Total: 0.7938 sf(s)

304/316 0.018 SHEET

(M304S26GA)

Batch: MT 101000

1.54

N

FF

06.09.15

8

2.0	SHEAR	SHEAR
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**Comment:** SHEAR

Cut as per Dwg D3477 (13.40" X 2.04")

FF

06.09.15

8

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

FF

06.09.18

8

2-Roll as per Dwg D3477

3-Tack Weld as per Dwg D3477

SB

06/09/20

8

4.0	QC5/9	WELD INSPECTION
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**Comment:** WELD INSPECTION

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: LD Date: 06/09/26  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 9/14/2006 7:29:40 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 28567

Part Number: D34773

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5444*

*10/6/9/26*  
*06/09/26* (8)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*06/09/26* (8)

Job Completion



*11 Nov 9/26*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

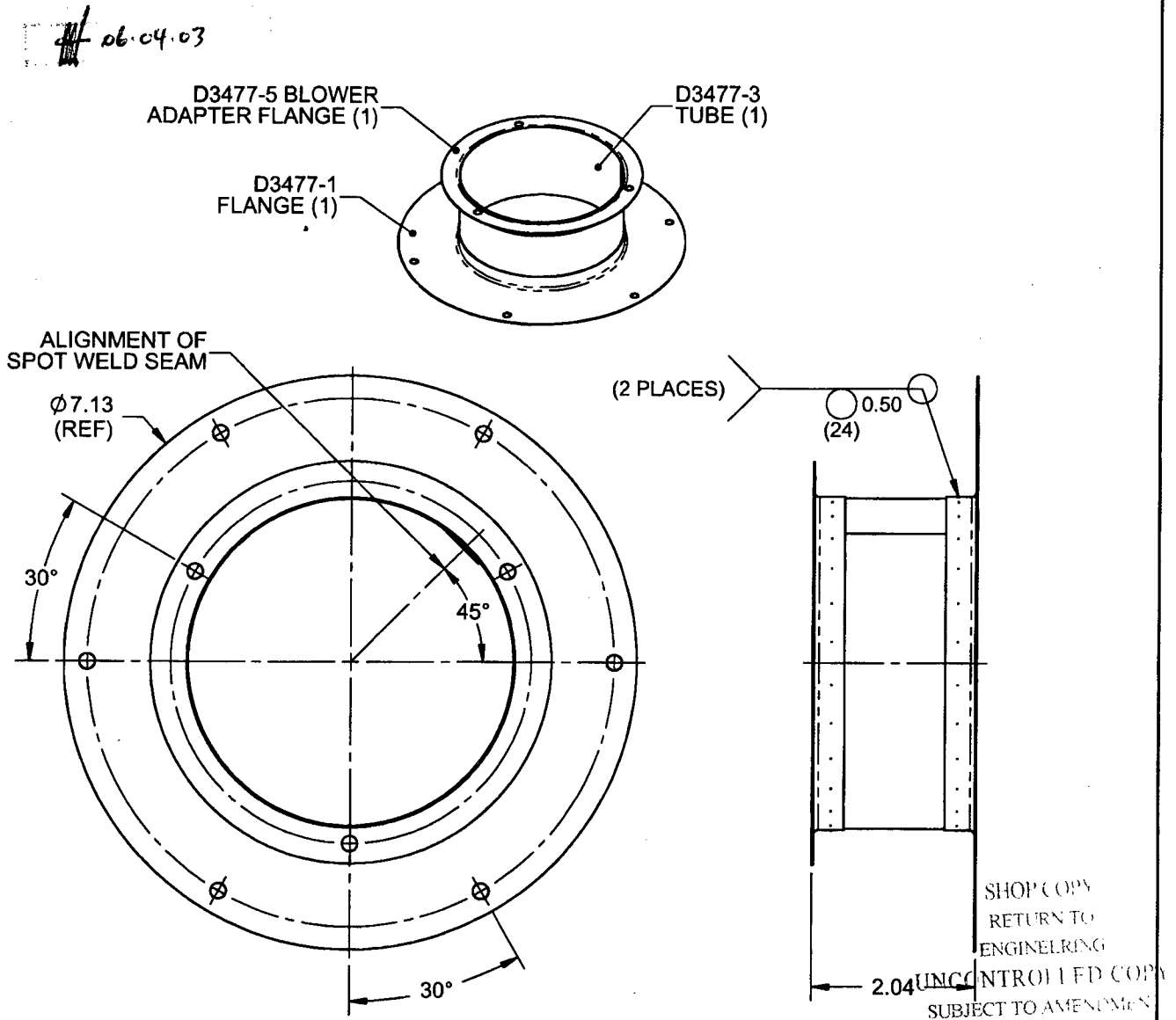
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3477</b>	REV. A SHEET 1 OF 4
DATE <b>05.12.09</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:2
A	05.12.09	NEW ISSUE	

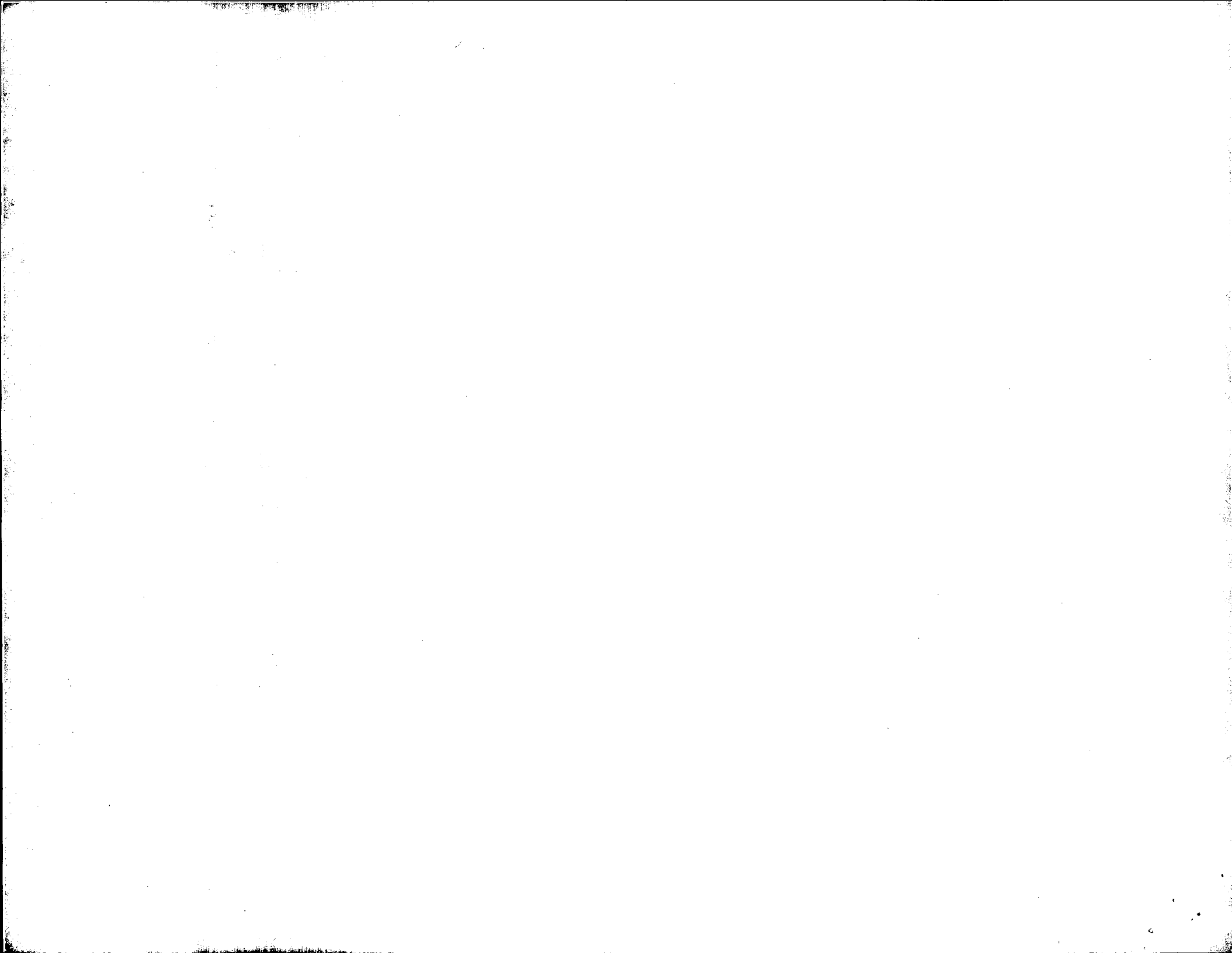
**D3477-041 BLOWER MOTOR INLET ADAPTER****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3477-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3477-041	BLOWER MOTOR ASSEMBLY
1	D3477-1	FLANGE
1	D3477-3	TUBE
1	D3477-5	BLOWER ADAPTER FLANGE

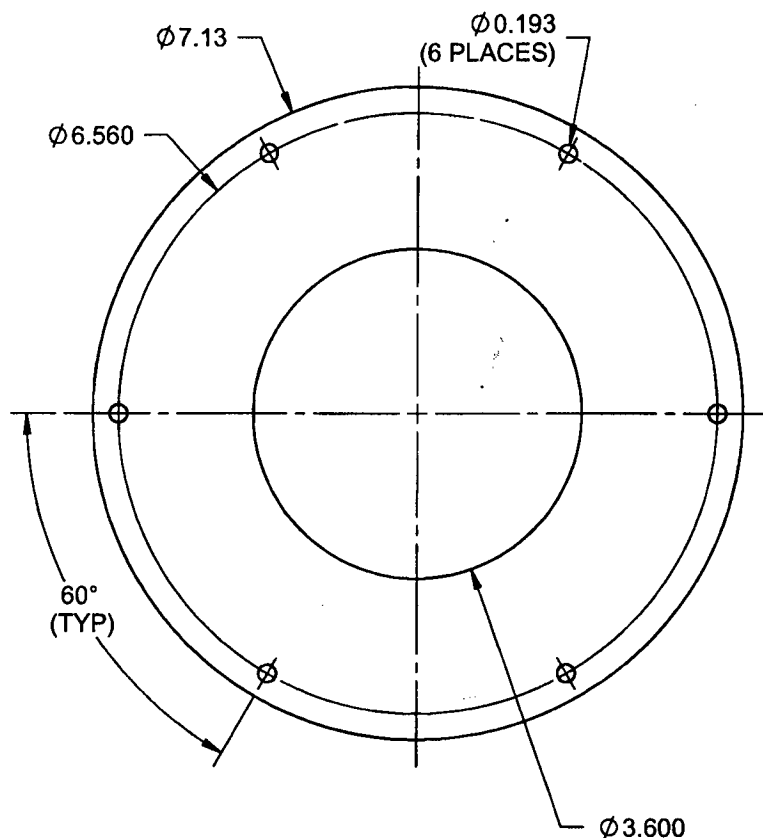
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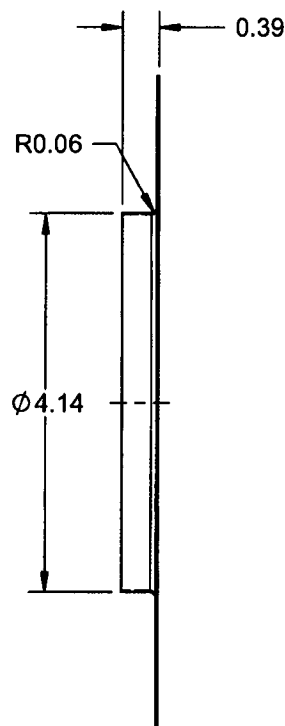




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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3477	REV. A SHEET 2 OF 4
DATE 05.12.09		TITLE BLOWER INLET ADAPTER	SCALE 1:2



**D3477-1F FLANGE  
FLAT PATTERN**



**D3477-1  
FLANGE**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER  
NO. 28567

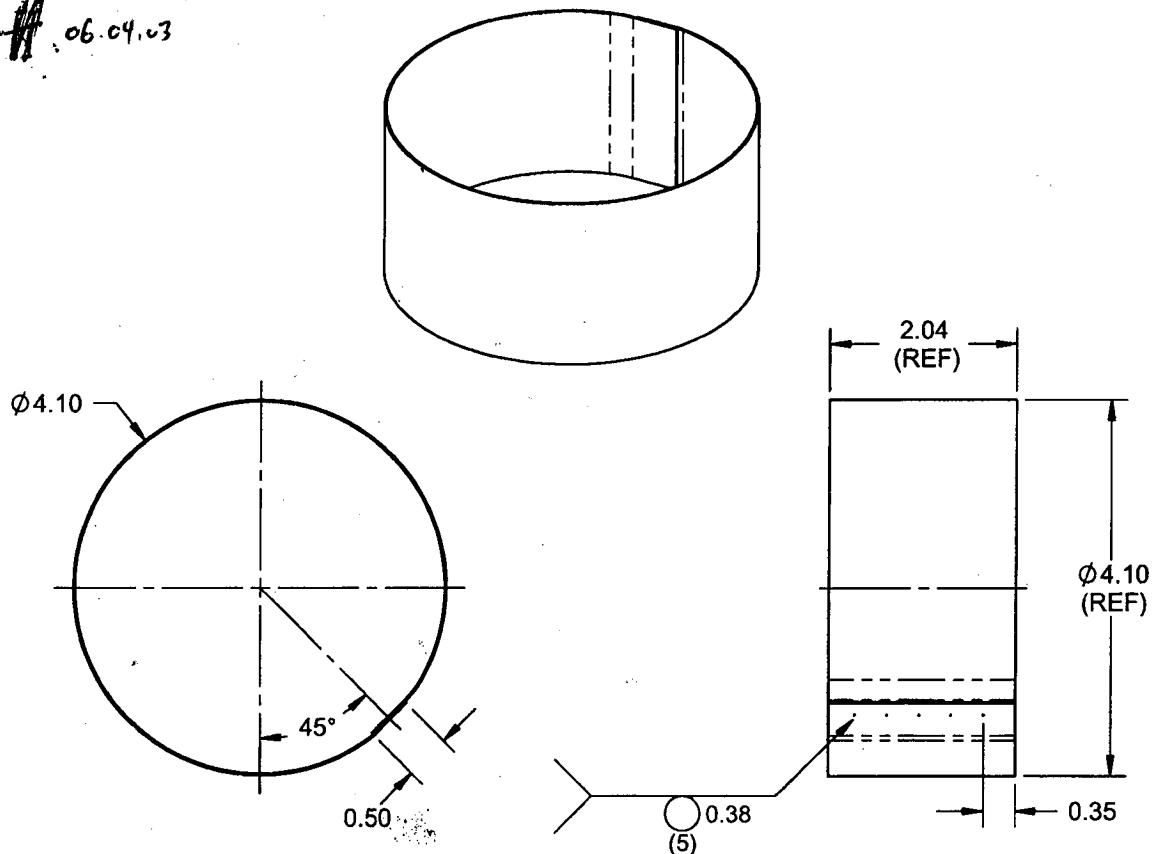
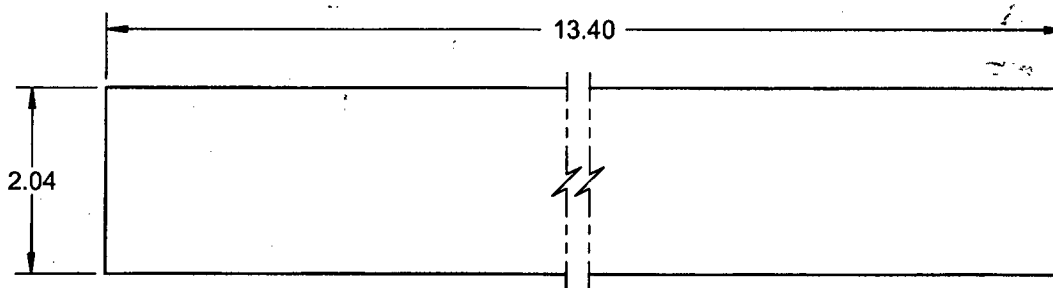
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DATE <b>05.12.09</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:2

# 06.04.03

**D3477-3 TUBE****D3477-3F TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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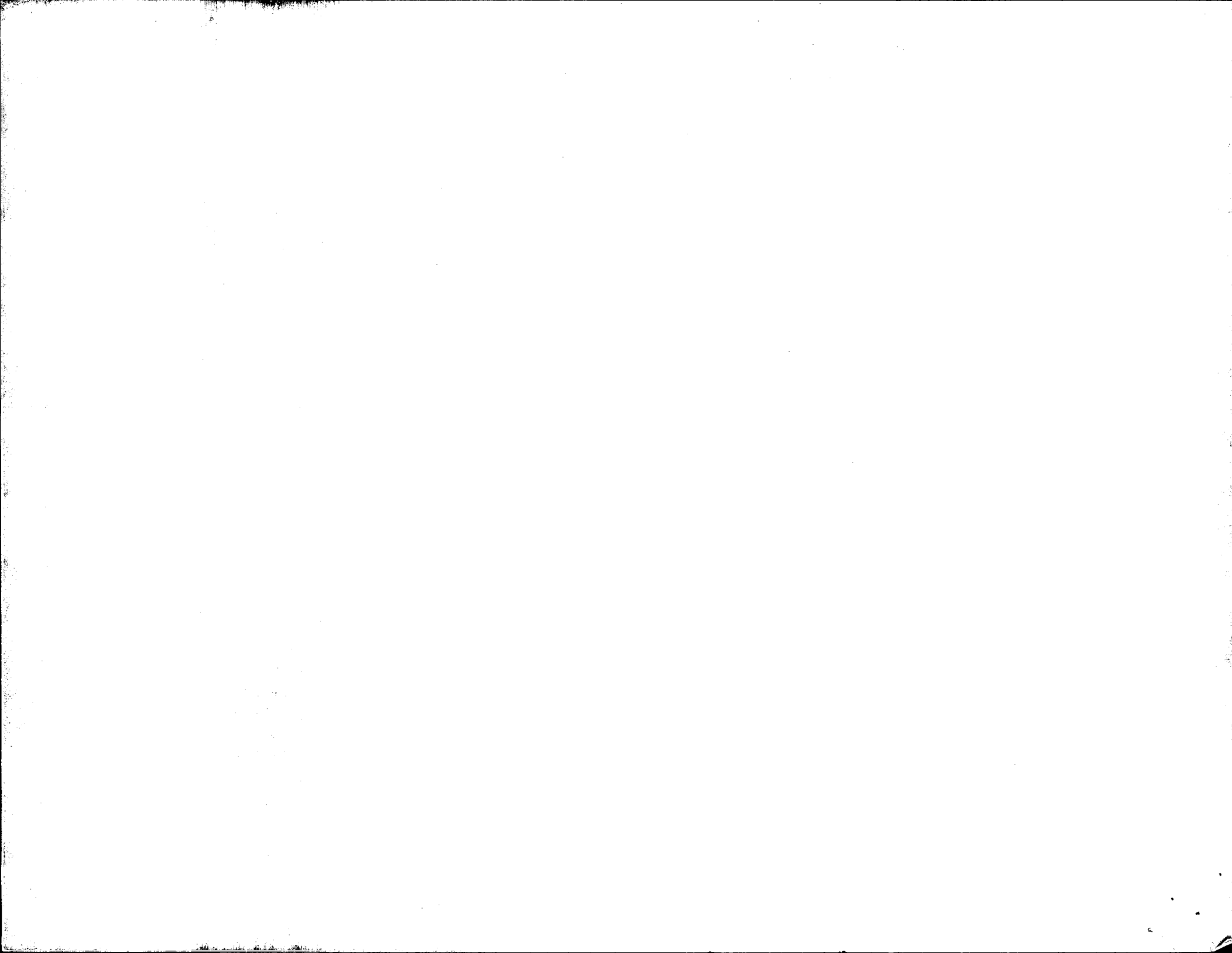
WORK ORDER

NO. 28567

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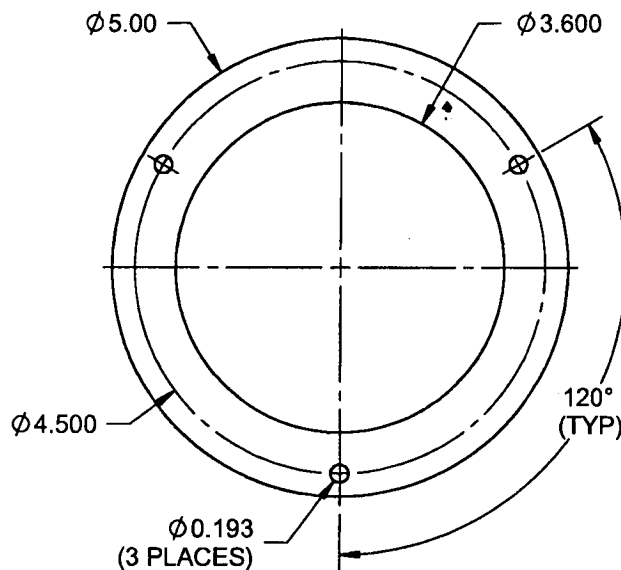
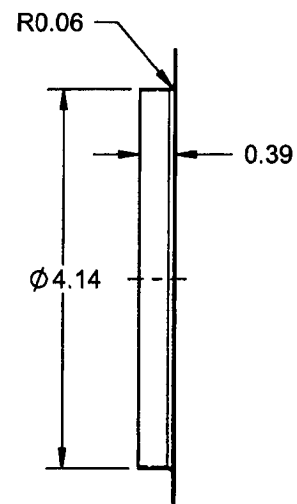
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DATE <b>05.12.09</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:2

*# 06.04.03***D3477-5F FLAT PATTERN****D3477-5 BLOWER  
ADAPTER FLANGE****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 10

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name Sylvie Bouchon  
Joint Welding Procedure Spot weld  
Part number and Job number A34773 / B28567

TEST WELDS REQUIRED

BASE METAL S.S WELDING PROCESS Spot weld  
Penetration Complete ☒ Partial ☐ Single Weld ☒ Double Weld ☐  
Current AC ☐ DC ☒ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into \_\_\_\_\_ Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐  
Penetration Pass ☒ Fail ☐

Crossbolt Spacer Pass ☐ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/09/20 Qualifier David Dural